



Dart Aerospace Ltd.  
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**D3914-041**  
**Job Sheet 188188**



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC  
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD  
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 1 Ea  | 1/24/19    | 1/24/19  | 0.00      | 0.00    | Start Up Large Fab-5  |           | MTL            |
| 100   | Large Fab          | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 6.67    | Large Fab 1           |           | CAL 16-01-2019 |
| 110   | QC                 | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.00    | QC9                   |           | CAL            |
| 120   | QC                 | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.00    | QC5                   |           | CAL            |
| 130   | Powdercoat         | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.40    | Powdercoat4           |           | BER 19-01-18   |
| 135   | QC                 | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.00    | QC3                   |           | JL 19-01-22    |
| 140   | HandFinish         | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.80    | HandFinish3           |           | JL 19-01-22    |
| 150   | QC                 | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.00    | QC3                   |           | BER 19-01-22   |
| 160   | Packaging          | 1 pcs | 1/24/19    | 1/24/19  | 0.00      | 0.00    | Packaging3-2          |           | BER 19-01-22   |
| 170   | QC21-SA            | 1 Ea  | 1/24/19    | 1/24/19  | 0.00      | 0.00    | QC21                  |           | BER 19-01-22   |

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg  
Descriptions: D3914 \*\*\*Visual inspect before welding mesh\*\*\* 3- tack weld mesh on basket as per dwg D3914 \*\*\*Cut out mesh where  
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label  
plate before tacking mesh\*\*\*

130 - \*\*\* mask sides of hinge prior to powdercoat\*\*\*

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg \*\*\*Mask  
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label\*\*\*

M138839 START: 7:45 TEMP: 320° FINISH: 8:15

### Job BOM

| Part / Item | Component Name                     | Quantity       | Operation             | Container |
|-------------|------------------------------------|----------------|-----------------------|-----------|
| D2581 ✓     | Mounting Bracket                   | 2 pcs (2 ea) ✓ | 90-Start up Operation | 5125289   |
| D3914-1 ✓   | Rib                                | 2 pcs (2 ea) ✓ | 90-Start up Operation | 5140402   |
| D3914-7 ✓   | Rib                                | 2 pcs (2 ea) ✓ | 90-Start up Operation | 5139826   |
| D4016-3 ✓   | Hinge Half, Lid                    | 3 pcs (3 ea) ✓ | 90-Start up Operation | 5121277   |
| D4018-5 ✓   | Rib                                | 9 pcs (9 ea) ✓ | 90-Start up Operation | 5134802   |
| D4020-5     | Mesh (350 Basket Long, Lid)        | 1 pcs (1 ea)   | 90-Start up Operation | 5137016   |
| D4021-3 ✓   | Data Plate                         | 1 pcs (1 ea) ✓ | 90-Start up Operation | 5114284   |
| D4035-043 ✓ | Lid Rib Assembly, Aft (350 Basket) | 2 pcs (2 ea) ✓ | 90-Start up Operation | 5140450   |

### Job Allocations

| Operation | Component Part | Required | Inventory | Allocated |
|-----------|----------------|----------|-----------|-----------|
|-----------|----------------|----------|-----------|-----------|



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

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| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
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| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |

90-Start up Operation

|           |   |     |   |
|-----------|---|-----|---|
| D2581     | 2 | 15  | 0 |
| D3914-1   | 2 | 6   | 0 |
| D3914-7   | 2 | 6   | 0 |
| D4016-3   | 3 | 185 | 0 |
| D4018-5   | 9 | 18  | 0 |
| D4020-5   | 1 | 6   | 0 |
| D4021-3   | 1 | 12  | 0 |
| D4035-043 | 2 | 4   | 0 |

### Part Specifications

Specifications could not be found.

Plex 1/4/19 10:56 AM Dart.lajeunesse.marie



**Container No: S143799**



**Part: D3914-041**

**Job No: 188188**

**Serial No/Batch: S143799**

**Revision: A/D**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Dart Aerospace Ltd.**  
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Email: sales@dartaero.com  
www.dartaerospace.com

Date: 01/10/19



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

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| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Presservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
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